Work Order I Friday, February 15				*9	734	.8*			V	Mark		Page 1
Revision ID:	876-5		,	Accept	*	N900	<u>)</u> 040	100)* s	Setup Star	1 1	S1*
	tector - LH \(\) 5/2013 2/2013	Wall Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			Cust Item Customer				Sto	° *N	S2*
Approvals: Pr	ocess Plan	i: MY	Date: \3-2-19 Date:	Tooling: SPC (Y/N)):		Date:		F	Run Star Sto	1/1	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Ho		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3876	Revis REV	sion Nbr A							·		· · · · · · · · · · · · · · · · · · ·	
*100 *100* Waterjet FLOW CNC Waterjet		FLOW WATER JET Memo 1-Cut as pe	r Dwg D3876	0.00					6.		· · · · · · · · · · · · · · · · · · ·	JM13-2-20
		Dwg Rev:_ Prog Rev:_ 2- Deburr if	A									
*110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00					6	0		Jm13-2-2
QC Quality Control		Мето		0.00					6			ع - در المارك
120 *120*		QC8- Inspect parts - sec	ond check	0.00	OAS:				/			
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Quality Control

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						T					QA Closed:	Date:	
Work Orde	ar.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde						Rework	7 I		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No					Scrap]	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is]		noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	No					Work Order Update	┛╏		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
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Operator													
Material	Щ												
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Unapproved			<u></u>	<u></u>		·	: 1111	T CATE	COBY		L		1
Landir						General	AUL	LICATE	GURT				
Lailuit		ar ending				Bend	<u> </u>	Grain			Ovalized		Pressure/Forced

Temperature/Cure Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Part Lost/Missing Instructions Incomplete/Unclear Crushed/Crimped. Burrs Maintenance Part Moved Cuffs Contamination Positioned Wrong Heat Treat Countersink Mislabeled Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Out of Sequence Turning Sequence Finish Folio Outside Dirnensions Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

140

OC21- Final Inspection - Work Order Release

0.00

OC

Quality Control

Memo

0.00

MF () 13-2-25

Insp.

Page 2

NCR:	⁄es	/ No				WORK ORDER NON-C	ON	IFORM	MANCE / UP	DATE	QA Clos	ed:	Date:	
Mark Ond				•		DISPOSITION				AGAINST D				
Work Orde Part N NCR N	- . No.					Rework Scrap Use-as-is Work Order Update		ı	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	l	nitial	Ac	tion	Sign 8	Ž.		
Cause		Date	Step	Qty	C	or Non-conformance	Chi	ief Eng	Desc	ription	Date	:	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUL	T CATE	GORY					
Landi	$\overline{}$					General Bend		Grain		Γ	Ovalized	1		Pressure/Forced
	ш	Bending Centre No	ot Concer	ntric to	o/s	BOM/Route	\vdash	Hardwa	ıre				tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Burrs

DQA:

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Date:

Weld

Other

Wrong Stock Pulled

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Friday, February 15, 2013 2:24:23 PM

Work Order ID:

97348

Parent Item:

D3876-5

Parent Item Name:

Protector - LH Wall

Start Date: 2/15/2013

Required Date: 2/22/2013

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 09-01-14 new issue DD verifyed by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	0.0000	12.04	76:0 42105			
GE PLASTICS LEXAN SI	HEET									100		J	413-2-20

124655

124655

												DQA:	Date	
NCR:	⁄es	/ No				WORK ORDER NON-		NFORM	MANCE / UP	DATE				
						,						QA Closed:	Date	•
Work Orde	or.					DISPOSITION		•		AGAINST	DE	PARTMENT	PROCESS	
Part NCR I	۱o.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	П	nitial	Act	ion		Sign &		
Cause		Date	Step	Qty	ļ ,	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
Doc/Data														
Equip/Tooling			ļ											
Operator														
Material														
Setup														
Other							1							
Process														
Supplier														
Training														
Unapproved														
						F	AUL	T CATE	GORY					
Landi	ng (Gear				General		-		,		,		 1
		Bending				Bend		Grain				Ovalized		Pressure/Forced
	L	Centre No	ot Conce	ntric to	O/S	BOM/Route		Hardwa	ire			Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspect	ion Incomplete			Part Incorre	ct	Weld
		Crushed/	Crimped.	•		Burrs		Instruct	tions Incomplete/	Unclear		Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance			Part Moved		
	Г	Heat Trea	at			Countersink		Mislabe	eled			Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

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DART AEROSPACE LTD	Work Order:	97348
Description: Protector – LH Wall	Part Number:	D3876-5
Inspection Dwg: D3876 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
20.68	+/-0.030	22.684	٠		T	Thro	6
81.4	+/-0.100	81.4"	-		T		
0.125	+/-0.010	0.126"	v		V	Thomas	L
							,
							
<u> </u>							<u></u>
			78				
easured by:	Tm I	Audited by:	75 25 89		Prototype A	pproval:	N/A
Date:	13-7-20		$\mathbb{Z}_{2}^{\mathbf{S}_{\mathbf{S}_{\mathbf{S}_{\mathbf{S}}}}}$, —		Date:	N/A

Measured by:	Im	Audited by:	75	Prototype .	Approval:	N/A
Date:	13-2-20	Date:	B221		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	09.06.22	New Issue	KJ 94	

